

D205.633-011

Dart Aerospace Ltd.

Date: Wednesday, 1/31/2007 2:33:43 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP WELDMENT
Job Number : 30508A	
Estimate Number : 10176	
P.O. Number : <i>N/A</i>	Part Number : D2563
This Issue : 1/31/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2563 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision : C
Previous Run : 30461A	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 2/20/2007 Qty: 10 Um: Each
Checked & Approved By : <i>[Signature] 07.02.01</i>	
Comment : Est Rev. 02.07.31 Re-format Location RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2244116	Step Extrusion
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Comment: Qty.: 1 Each(s)/Unit Total : 10 Each(s)

Pick:

1 D2244 Step Extrusion

Batch: *328216**P.E. 07-04-30*

10

2.0	D267334	End Plate
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Comment: Qty.: 2 Each(s)/Unit Total : 20 Each(s)

Pick:

Qty	Part No.	Description
2	D2673-34	End Cap

Batch: *325396**P.E. 07-04-30*

10

3.0	D2561	Lug Plate
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Comment: Qty.: 2 Each(s)/Unit Total : 20 Each(s)

Pick:

Qty	Part No.	Description
2	D2561	Lug Plate

Batch: *330384**P.E. 07-04-30*

10

4.0	D2564	Mounting Angle
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Comment: Qty.: 2 Each(s)/Unit Total : 20 Each(s)

Pick:

Qty	Part No.	Description
2	D2564	Mounting Angle

Batch: *321418**P.E. 07-04-30*

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 30508A

Part Number: D2563

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 to 89.70" at 34° as per Dwg D2563

2-Deburr ends

3-Weld (1 End CAP,LUG PLATES & MOUNTING ANGLE as per Dwg D2563 using DT 8343

A/R AL ROD

Batch:

M103317
M102756

4-Grind

P.E. 07.04.30 10

P.E. 07.04.30 10

P.E. 07.05.2 10

FF 07-05-03 10

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

07-05-15 10

07/05/15 10

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-1 07/05/15

10X

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-05-15 10

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Inspect for foreign object per QSI 024

2-Weld Remainig End as per Dwg D2563 using DT 8343

A/R AL ROD

Batch:

M102756

3-Grind

P.E. 07.05.17 10

P.E. 07.05.17 10

FF 07-05-17 10

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/05/17 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: 12 Date: 07/05/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:33:43 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 30508A

Part Number: D2563

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2005-17 (10)

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Touch up Alodine then

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M103 706

FD

07-05-22

07/05/22

(PTO)

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2563 and QSI 005 4.4

M/10 7281

M-P

07/05/23

(10x)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

1/1

7/5/24

(10)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

u 07-05-24

Job Completion



PPP SUB B32382 D205-633-011



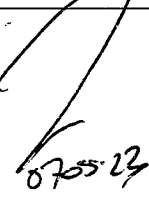



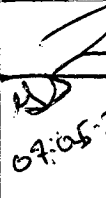
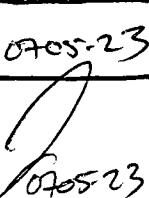
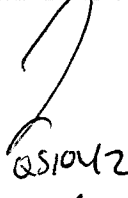

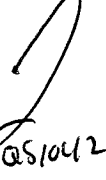
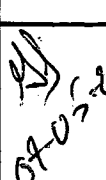
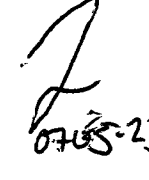
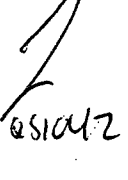
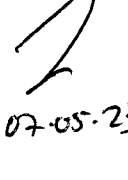
07/05/24 (10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

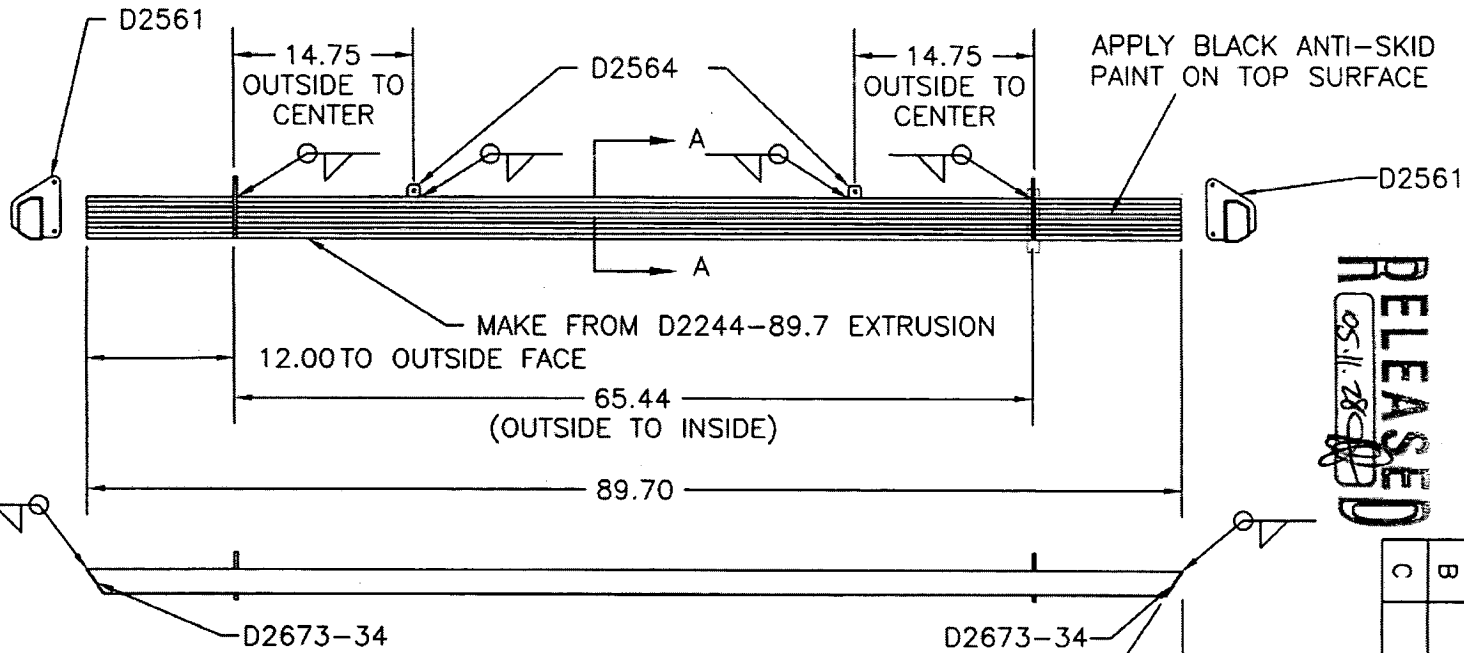
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-05-23	12.0	4 steps had some yellow strips that came through the powder coating. Root cause: Yellow paint on the buggy rubbed off on the step.	 QS1042	Sand affected area with 320 grit sand paper, and scuff with a red pad on the remainder of the step. Touch-up area's with Alodine	 07-05-23	 07-05-23	 QS1042	 07-05-23
↓	↓	↓	 QS1042	verify by Q.C. Pre-heat steps & re-powder coat white Pressure wash & vince per QS1005	 07-05-23	 07-05-23	 QS1042	 07-05-23
↓	↓		 QS1042	Pre-heat as necessary and re-powder coat per QS1005.	 07-05-23	 07-05-23	 QS1042	 07-05-23

NOTE: Date & initial all entries



RELEASED
05.11.28

DESIGN	BW	DRAWN BY	44	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	05.11.14	DRAWING NO.	D2563	REV. C
		TITLE	STEP WELDMENT ASSEMBLY	SHEET 1 OF 1
				SCALE
A		96.04.26	NEW ISSUE	1:15
B		97.05.14	END CAPS CHANGED (WAS D2248)	
C		05.11.14	UPDATE NOTES	



D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 305087A

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED